Dart Aerospace Ltd. Friday, 14/11/2008 10:21:39 AM User: Julie Dawson **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : GASKET Job Number : 43454 **Estimate Number** : 12719 : D353625 **Part Number** P.O. Number : 14/11/2008 : D3536 REV A S.O. No. : **Drawing Number** This Issue : NC : N/A Prsht Rev. **Project Number** First Issue : // Type : SMALL /MED FAB **Drawing Revision** : 42980 Material Previous Run 12 Um: **Due Date** : 28/11/2008 Qty: Written By Checked & Approved By Comment New Issue 07-02-14 JLM : Est Rev:A **Additional Product** Job Number: Seq. #: **Machine Or Operation:** Description: MNEO60S063 1.0 NEOPRENE SHEET 0.063 7.5046 sf(s) Comment: Qty.: Total: 0.6254 sf(s)/Unit **NEOPRENE SHEET 0.063** Batch: 109 864 WATER JET FLOW WATER JET 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D3536 Dwg Rev:__A B8-11-24 Prog Rev: _A__ 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 B8-11-24 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK PACKAGING 1 PACKAGING RESOURCE #1 5.0

Comment: PACKAGING RESOURCE #1 Identify and Stock

Location:

Each

Dart Aerospace Ltd

	Оораос		į.							1	
W/O:			i	W	ORK ORDER CHANG	GES					
DATE	STEP		PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			t L								
			1				į			· 1	
		,	!								
			1							t 	
			1								
Part No	:		PAR #:	Fault Cate	gory:	NCR	:Yes N	lo DQ	A :	Date: _	
	R	esolution:		Dispositio	n:	QA:	N/C Clo	sed:		Date:	
NCR:				WORK ORD	ER NON-CONFORM	ANCE	(NCR)		(
DATE	STEP		ription of NC	Initial		ction B	Sign &		ation	Approval	Approval
	J		Section A	Chief Eng	Action Description Chief Eng		Date	Secti	on C	Chief Eng	QC Inspecto
			f ·								
									i		
		,							•		
		i I							· ·		
		i I									
									,		
		,							· · · · · · · · · · · · · · · · · · ·		,
		1									
		r I							t L		

NOTE: Date & initial all entries

Date: User: Friday, 14/11/2008 10:21:39 AM

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 43454

Part Number: D353625

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-24

Dart Aerospace Ltd

W/O:			i i	W	ORK ORDER CHANG	SES			-		1
DATE	STEP		PR	OCEDURE CH	ANGE	:	Ву	Date Q	ty Chief	roval Eng / I Mgr	Approval QC Inspector
			1								
			i I								
			!								
	!) 								
			7 7 1								
Part No	·		PAR #:	Fault Cat	egory:	NCR	: Yes I	No DQA: _	D:	ate: _	<u> </u>
	R	esolution:	· -	Dispositi	on:	QA:	N/C Clo	sed:	Da	ate: _	· ·
NCR:		;	!	WORK ORI	DER NON-CONFORM	ANCE	(NCR))			
DATE	STEP	Desc	ription of NC			tion B	<u> </u>	Verificati	on App	roval	Approval
DAIL	SIEP		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C	Chie	f Eng	QC Inspector
		,	•								
		J.									
											:
		!									t
		i I									,
•		. i									
		!									
						į					
		i									
		!									

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 4345	
Description: Gasket	Part Number: D3536-25	
Inspection Dwg: D3536 Rev: A	Page 1 of	1

	X	RTICLE INSP First Article		Prototy			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Meth	od of ection	Comments
21.80	+/-0.030	21.80	A				
16.35	+/-0.030	16.35	8				,
10.90	+/-0.030	10,913	X				
5.45	+/-0.030	5,455	X				
6.00	+/-0.030	6.003	8			•	
6.75	+/-0.030	6.758	ه				
12.75	+/-0.030	12.75	×				
1.89	+/-0.030	1908	X c				
0.30	+/-0.030	,309	80				
0.30	+/-0.030	.309	کھ				
Ø0.19	+0.005/-0.001	193	X)				
leasured by:	B9-11-24	Audited by:	25/11/26	, 	ototype	Approval:	N/A N/A
Rev Date	Change				· · · · · · · · · · · · · · · · · · ·	Revised by	Approve
A 07.06.12						Revised by	7001010

Rev	Date	Change	 Revised by	Approved
Α	07.06.13	New Issue	KJ/JLM	尼

CHECKED

B

#

D3536

SHEET 1 OF 6

SCALE ::0

REV.

DRAWING NO.

DART

AEROSPACE

R C

PORT HADLOCK,

≸

DATE

06.10.25

GASKET

06.10.25

NEW ISSUE

29.02.12

26.65	!
23.15	
21.15	
17.65	
13.40	
9.15	0.90
5.65	1
Q-	1.89
DETAIL A - - 8.00 - 3.90	
(TYP 3 PLS)	

D3536-11 GASKET

27,40 23.90 18.98 14.07 0.90 5.65 1.89 DETAIL A 3.90 #0.19 (TYP 4 PLS) E RETURN TO ENGINEERING COPY 20.00 SUBJECT TO AMENDMENT

D3536-13 GASKET

봀

DOCUMENT IS

Copyright @ 2006 by DA PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EX OR COMMUNICATED TO ANY OTHER PERSON WITHOUT

DART AEROSPACE

EXPRESS CONDITION THAT

EROSPACE USA, INC.
CONDITION THAT IT IS NOT TO BE USED FOR ANY PERMISSION FROM DART AEROSPACE USA, INC.

PURPOSE

윷

COPIED

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

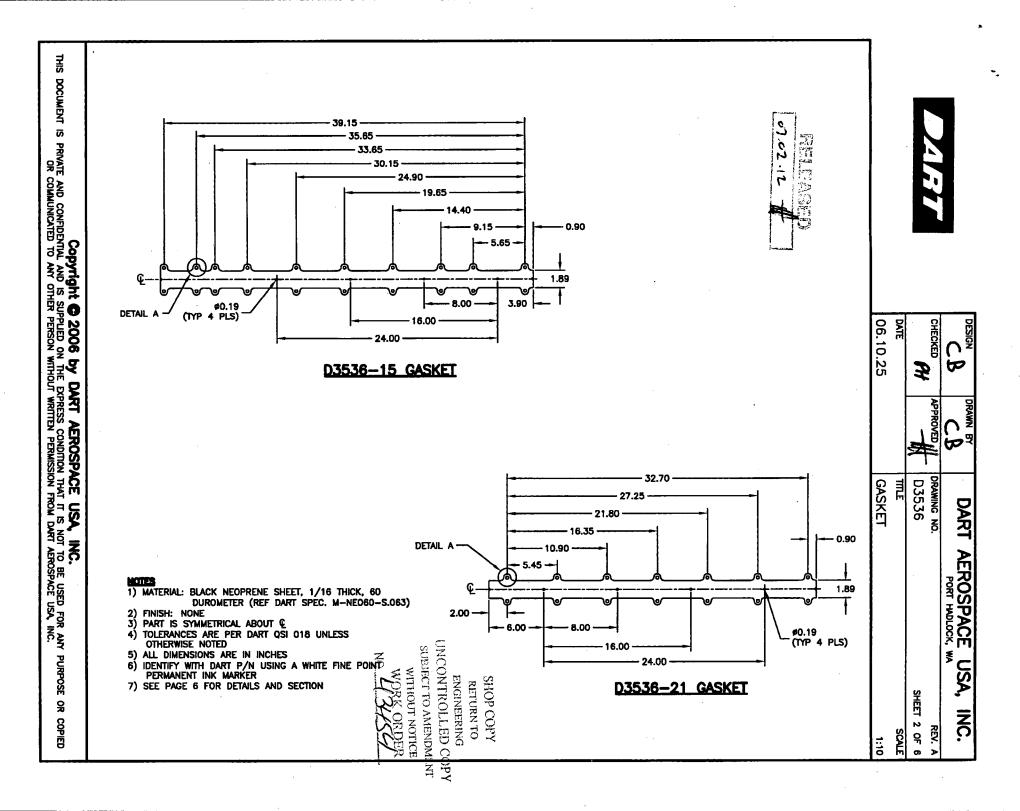
2) FINISH: NONE 3) PART IS SYMM

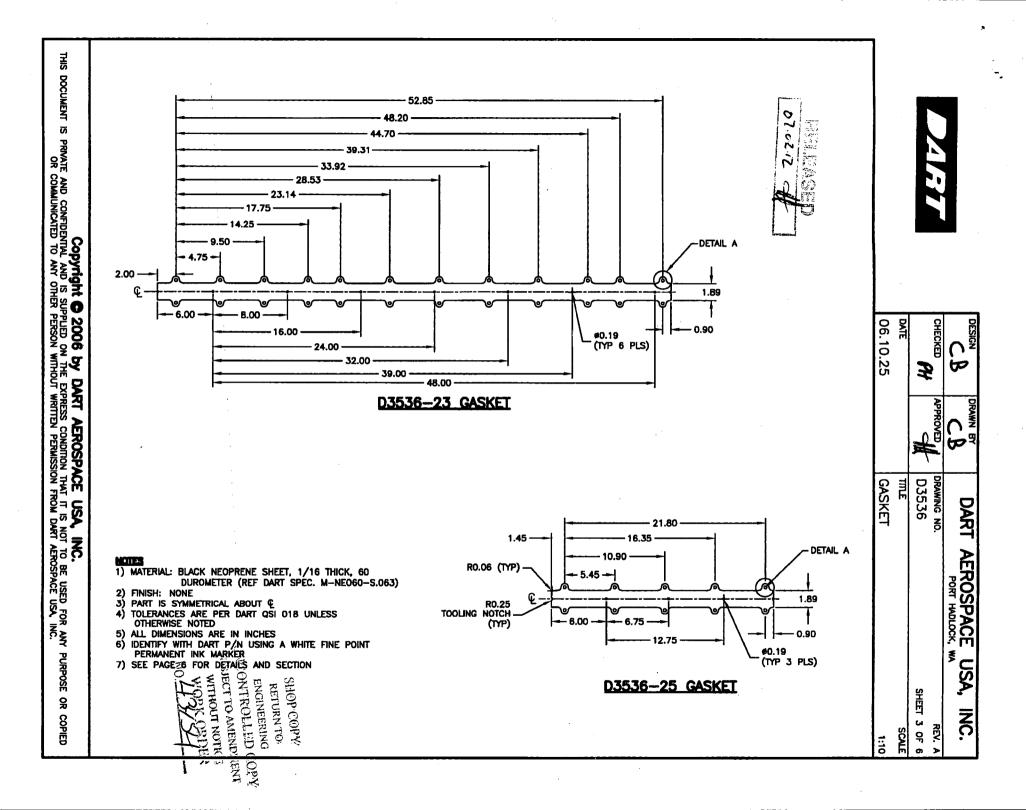
) PART IS SYMMETRICAL ABOUT ©
) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

WITHOUT NOTICE ORDER

SHOP COPY

ALL DIMENSIONS ARE IN INCHES
IDENTIFY WITH DART P/N USING A WHITE FINE POINTS
PERMANENT INK MARKER
SEE PAGE 6 FOR DETAILS AND SECTION 7) SEE PAGE 6 FOR DETAILS AND SECTION





切

DART

AEROSPACE

ASU,

NO.

£

DRAWING NO.

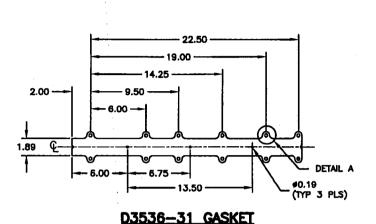
SHEET

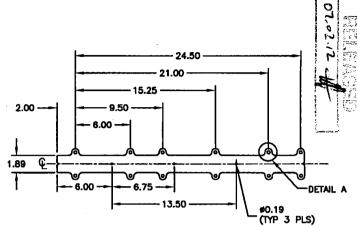
4 OF 6

1:10

GASKET







D3536-33 GASKET

-	~	п	$\overline{\mathbf{x}}$	ı

봀

DOCUMENT

Ö

Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

PURPOSE

욹

COPIED

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE: 6 FOR DETAILS AND SECTION

	23.25
2.00 —-	14.25
-	4.75
1.89 €	
1 1-	- 6.00 6.75 - (TYP 2 PLS) DETAIL A

D3536-35 GASKET

"	SEE	EVO	Z	rur	V	CIA
7	MICHON TONION IN	CUBJECT TO AMENDMEN	CONTE	ENG!	RET	OHS
777	MITHOU NOTIFIE	OAME	SOLLEI	ENGINEERING	RETURNTO	SHOP COPY
7	道	TOMENT	D COI	G G		

07.02.12

32.78 29.28

#0.19 (TYP 3 PLS)

28.00

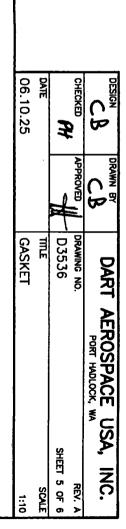
D3536-39 GASKET

25.78

23.25

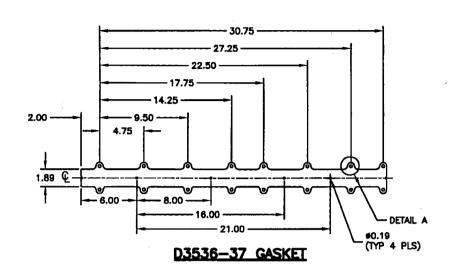
9.00





1.88

DETAIL A



봀

DOCUMENT

ᄶ

Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

PURPOSE

옃

COPIED

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI D18 UNLESS
 OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
 PERMANENT INK MARKER
 2) SEE PACE & EAR DETAILS AND SECTION
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE ENGINEERING RETURN TO

2.00 -

--- 5.00 -

SHOP COPY



1:10	GASKET		06.10.25	
SCALE	TIME.		TIAD	
SHEET 6 OF 6	D3536	#	77	
REV. A	DRAWING NO.	APPROVED //	CHECKED	
PORT HADLOCK, WA	DAKI	CB	CB	



R0.37

DETAIL A

RO.38

RO.11

0.30

0.19



D3536-41 GASKET

#0.19

(TYP 2 PLS)

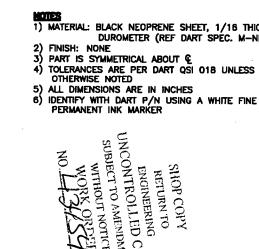
3.90

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.083)

18.50

- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER





Ω Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

PURPOSE

욹 COPIED 2.00 -

4.00

DETAIL

봀